

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009582**Date Inspected:** 14-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Segment6CE

During a random verification of Magnetic Particle (MT) Testing of the OBG Segment 6CE welds. The Caltrans Quality Assurance (QA) inspector discovered a total of three (3) Linear Indications approximately 12mm to 20mm in length located at the Deck Panel Stiffeners (SPCM) welds # Seg32H-065,123 and 023. ZPMC personal completed the weld repairs of the above mentioned welds without prior approval of the Engineer. These welds have been previously tested and accepted by ZPMC Quality Control MT technicians. For further information, please see incident report on this date.

During random verification Magnetic Particle Testing of the OBG Segment 6CE Welds, Caltrans Quality Assurance Inspector found total three (3) Linear Indications approximately 12mm to 20mm in length in Weld# Seg32H-065, 123 and 023. According to approved weld detail drawings, these welds are fracture critical welds. ZPMC personal completed weld repair of the above mentioned welds without prior approval of the engineer. For further information, please see incident report on this date.

Bay#14

SMAW welding of weld joint Seg055A-010 located on 9DW. Welder is identified as 045246(4G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable

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WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint Seg055A-009 located on 9DW. Welder is identified as 058242(4G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SSD13A-PP073-004 located on 9AW. Welder is identified as 037779 and 070007 (2F). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

FCAW welding of weld joint SSD13A-PP072-007 located on 9AW. Welder is identified as 202122 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2a-F.

FCAW welding of weld joint Seg57*-004 located on 9EW. Welder is identified as 067876 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-223(2)1-T-2.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
